

# Work Order ID 51615

August 27, 2009 8:27:02 AM

Page 1

Item ID: D3646-3 **BK**

Accept

Revision ID: B

Item Name: Arm

Setup Start

Stop

Start Date: 8/27/09 Start Qty: 10.00

Required Date: 9/11/09 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: *[Signature]*

Date: *08-27* Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3646

Rev A

100



Brake NC

Brake NC

NC BRAKE

Memo

1-Punch to length as per Dwg D3646 & template DT8959

0.00

0.00

*m-h 09/09/14*

110



Small Fab

Small Fab

Small Fab

Memo

1-Deburr

2- Bend as per dwg D3646

0.00

0.00

*m-h 09/09/14*

*(10X)*

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

*2> 8/28/14*

*(410)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 51615

August 27, 2009 8:27:02 AM



Item ID: D3646-3

Accept



Setup Start



Revision ID: B

Stop



Item Name: Arm

Start Date: 8/27/09

Start Qty: 10.00



Cust Item ID:

Required Date: 9/11/09

Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

START TIME:

8:30AM

OVEN TEMPERATURE:

320°F

FINISH TIME:

9:00AM

0.00

M 09/09/17

(x10) Ø

Powder Coating

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BK 09-09-17

(10)

150

Identify as per dwg & Stock Location: 200

0.00



Packaging

Memo

0.00

Packaging

9/9/18 (10x) SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 51615

August 27, 2009 8:27:02 AM



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Item ID: D3646-3

Accept



Setup Start



Revision ID: B

Stop



Item Name: Arm

Start Date: 8/27/09

Start Qty: 10.00



Cust Item ID:

Required Date: 9/11/09

Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/21 *[Signature]*  
MF 09-09-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

August 27, 2009 8:27:01 AM

Page 1

Work Order ID: 51615

Parent Item: D3646-3RevB

Parent Item Name: Arm

Comments:

Start Date: 8/27/09

Required Date: 9/11/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TR0.500W.035		Purchased	No			110	f	272.6230	30.6316			



304 RD Tube .500 x .035W



## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

272.6230097

108250

2.23

111097

24.687936

111704

31.6682737

112187 ✓

214.0368

M-L 09/09/14

M112187

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

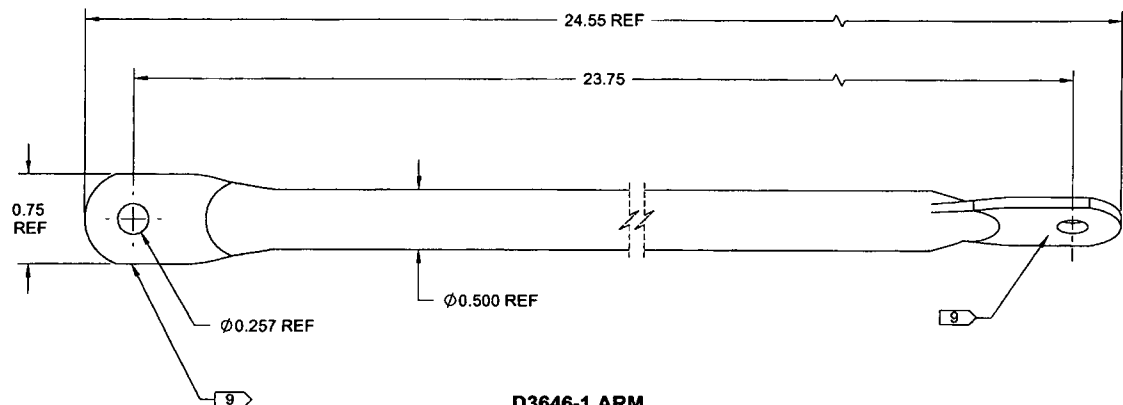
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

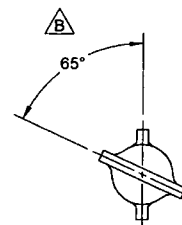
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**D3646-1 ARM**



**NOTES:**

- 1) MATERIAL: AISI 304/316 SS TUBE  $\phi 0.500 \times 0.035$  WALL PER ASTM A213/A269 OR ASME A213 (REF DART SPEC. M304TR0500W.035)
- 2) FINISH: POWDER COAT "BLACK SANDETEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3646-1" USING REMOVABLE TAG
- 7) WEIGHT: 0.38 lbs
- 8) MAKE PER TEMPLATE DT8958
- 9) PUNCH BOTH ENDS PER SPEC CONTROL DWG D2727

51615

**RELEASED**  
07/06/23/14

B	REFORMAT DWG, ANGLE 65° WAS 45° (ZN C3-1), ADD IDENTIFICATION TAG (ZN A8-1, A8-2)	CP	09.06.04
A	NEW ISSUE	MB	07.06.06
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.06.04		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3646** REV. B  
SHEET 1 OF 2  
TITLE **ARM** SCALE NTS

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